



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

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RBW6205G13831-3G

Job Sheet 173110



Part No: RBW6205G13831-3G

Job Qty: 1 ea

Part Name: AW139 Swashplate Kit Box 2



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 2/26/18

Job Tracking No:

Due Date: 3/9/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG RBW6205G13831-3G REV 2 IPP REV A 18.02.15 NEW ISSUE FK VERIFY DP

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea		3/8/18	0.00	0.00	Start Up Small Fab-4		MLC
110	Small Fab	1 pcs		3/9/18	0.00	1.00	Small Fab-4		MLC DAS
120	QC	1 pcs		3/9/18	0.00	0.00	QC5		DAS 38
130	Packaging	1 pcs		3/9/18	0.00	0.00	Packaging3-1		DAS 21 9-89
140	QC21-FG	1 Ea		3/9/18	0.00	0.00	QC21		9-89

Part Op 110 - 1-Engrave placard RB41011 using marktronic engraver 2-Transfer drill Dart placard RB41011 into Pelican case
Descriptions: APP-1600-E 3-Deburr holes and remove chips from case. 4-Rivet Dart placard to Pelican case 5-Glue placard
RBW6205G13831-3G-9 to RBW6205G13831-3G-7 foam as per DWG. 6-Glue foam to case and pack case as per DWG.

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
97524A032	Blind Rivet	4 Ea (4 ea)	90-Start up Operation	5031249
3777T12 27	Spring Catch	2 Ea (2 ea)	110-Small Fab	5054247
APP-1600-E GA	Case -	1 Ea (1 ea)	110-Small Fab	5068600
RB41011	Dart Tooling Placard, Aluminum	1 Ea (1 ea)	110-Small Fab	5021040
RBW6205G12731-3G 161	Upper Plate Assembly -	1 Ea (1 ea)	110-Small Fab	5067417
RBW6205G13151-3G 156	Lower Plate -	1 Ea (1 ea)	110-Small Fab	5067543
RBW6205G13231-3G 138	Arm Assembly -	3 Ea (3 ea)	110-Small Fab	5067410
RBW6205G13531-3G 96	Screw Assembly -	1 Ea (1 ea)	110-Small Fab	5065512
RBW6205G13831-3G-1	Shelf Backing -	1 Ea (1 ea)	110-Small Fab	
RBW6205G13831-3G-11	Dynamometer -	1 (1 ea)	110-Small Fab	5071980
RBW6205G13831-3G-3	Shelf -	1 Ea (1 ea)	110-Small Fab	
RBW6205G13831-3G-5	Bottom Foam -	1 (1 ea)	110-Small Fab	5068601
RBW6205G13831-3G-7	Lid Foam -	1 (1 ea)	110-Small Fab	5068602
RBW6205G13831-3G-9 98	Location Placard -	1 Ea (1 ea)	110-Small Fab	5061630

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	97524A032	4	255	0
110-Small Fab	3777T12	2	0	0
	APP-1600-E	1	0	0
	RB41011	1	944	0
	RBW6205G12731-3G	1	0	0
	RBW6205G13151-3G	1	0	0

QA Closed: _____ Date: _____

Work Order update only

Work Order: _____		DISPOSITION		AGAINST DEPARTMENT/PROCESS	
Part No. _____		Rework ☐	Skid-t ☐	Pressure tube ☐	Water Jet ☐
NCR No. _____		Scrap ☐	Machi ☐	Eng. Coord. ☐	Engineering ☐
		Use-as-is ☐	Thermofo ☐		Quality ☐
		Suspected Unapproved ☐	Larg ☐		Other ☐
Date :	Step #:	QTY		2) Approval	
Description Work Order Deviation					
				Completed By	
				Id / Supervisor	
				ral Verification	
				QA Coordinator Approval	
Root Cause					
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Tem ☐	ositioned Wrong	
Design ☐	Operator ☐	Bending ☐	Set- ☐	Outside Dimensions	
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOI ☐	Over/Under tolerance	
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Brc ☐	Part Incorrect	
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Ins ☐	Part Lost/Missing	
Material ☐	Use for Testing ☐	Cuffs ☐	Cc ☐	Part Moved	
Internal Transport ☐	Poor Information ☐	Crushing ☐	C ☐	Drawing	
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	C ☐	Finish	
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	I ☐	Misread	
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Turning Sequence	
Past Expiry Date ☐	Manufacturing Process ☐				
Misidentified ☐	Past Due ☐	OTHER :			

RBW6205G13231-3G	3	0	0
RBW6205G13531-3G	1	0	0
RBW6205G13831-3G-1	1	0	0
RBW6205G13831-3G-11	1	0	0
RBW6205G13831-3G-3	1	0	0
RBW6205G13831-3G-5	1	0	0
RBW6205G13831-3G-7	1	0	0
RBW6205G13831-3G-9	1	0	0

Part Specifications

Specifications could not be found.

Plex 2/26/18 10:59 AM Dart.lajeunesse.marie

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

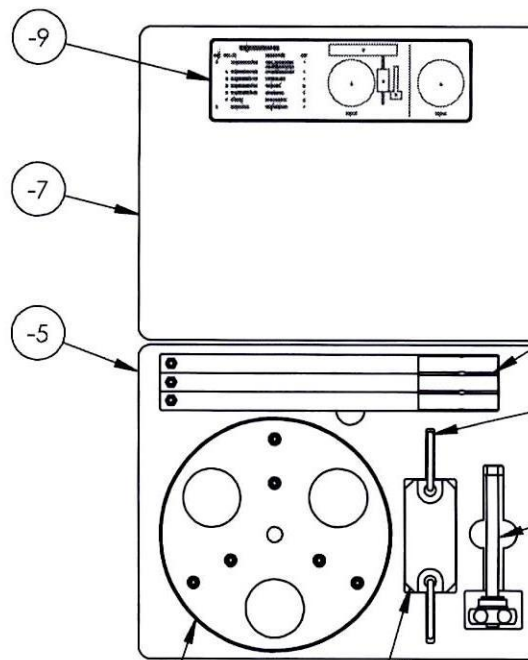
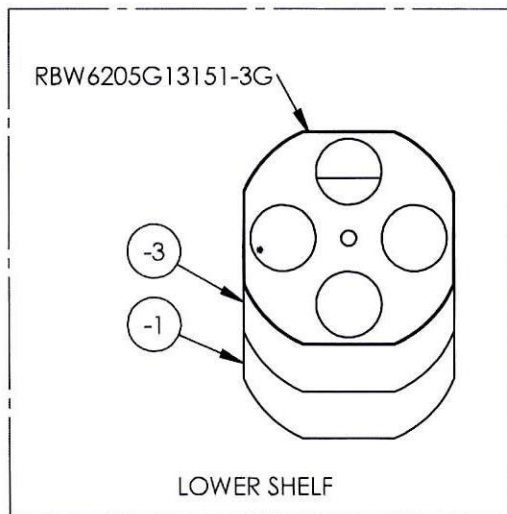
Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER :							
Misidentified ☐	Past Due ☐								

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
1		-1 & -3 ADDED NOTE. -5 CH'D OVERALL DIMENSIONS TO FIT CASE TIGHTER. -7 CH'D OVERALL DIMENSIONS TO FIT CASE TIGHTER, CH'D CUTOUT TO RECESSED POCKET ADDED CUTOUT ON BOTTOM FOR CASE PIN CLEARANCES AND MATERIAL FROM C200 FLAT TO 1780 FLAT BLACK.	6/29/2011	RJC	RW
2	15-0151	-5 CH'D CUTOUT SIZE AND DEPTH FOR -11 & -13. CH'D DIM WAS ∇ 1.00 IS ∇ 1.60 FOR RBW6205G13231-3G. -7 CH'D FOAM WAS 1780 FLAT, BLACK IS Y20 BLACK, CH'D CUTOUT DEPTH FOR PLACARD WAS .063 IS .13. -9 REMOVED TEXT "CONTENT LIST", CH'D DESCRIPTION WAS PLACARD IS LOCATION PLACARD.	7/8/2015	RJC	JAG

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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 173110M15
1802-26



RBW6205G12731-3G HANDIFOR-20

RBW6205G13231-3G 3X

540.06K-L (SPRING CATCH) 2X

RBW6205G13531-3G

ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
				1	UPPER PLATE ASSEMBLY		RBW6205G12731-3G	1
				1	LOWER PLATE		RBW6205G13151-3G	1
				3	ARM ASSEMBLY		RBW6205G13231-3G	1
				1	SCREW ASSEMBLY		RBW6205G13531-3G	1
		B/O	-1	1	SHELF BACKING	COROPLAST	BLACK, 6mm Ø12-7/16 I.R. SPECIALTY	2
		B/O	-3	1	SHELF	Y20 BLACK	Ø12-7/16 X 13/16	3
		B/O	-5	1	BOTTOM FOAM	Y20 BLACK	6-1/8 X 16-3/4 X 21-3/4 I.R. SPECIALTY	4
		B/O	-7	1	LID FOAM	Y20 BLACK	1-3/4 X 16-3/8 X 21-5/16 I.R. SPECIALTY	5
			-9	1	LOCATION PLACARD	PLASTIC		6
		B/O	-11	1	DYNAMOMETER		HANDIFOR-20	1
		B/O	-13	2	SPRING CATCH	S.S.	Ø5/16 CARABINER STYLE (MCMASTER-CARR #3777112)	1
		B/O	-15	1	CASE	PLASTIC, BLACK	8 X 17 X 22 PELICAN #APP-1600-E	N/S
		B/O	-17	1	DART PLACARD	ALUMINUM	#RB41011	N/S

NOTE:
PART OF KIT RBW6205G11231-3G.

DART AEROSPACE	
TITLE AW139 SWASHPLATE KIT	
DWG NO. RBW6205G13831-3G	REV 2
MATL UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/8 .XX ± .01 ANGLES ± 5° .X ± .1	DRAWN BY: CLOUGH APPROVED <i>D Weil</i> HEAT TREAT FINISH SPEC
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R	USED ON MODEL AW139
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
SCALE 1:10	DATE 1/31/2011
SHEET 1 OF 6	

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date : _____		Step #: _____		QTY Effective : _____			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
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Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
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Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								